

Work Order ID 73966

Tuesday, September 20, 2011 10:19:58 AM



Page 1

Item ID: D135-692-011

Accept



Setup Start



Revision ID:

Item Name: Bearpaw

Stop



Start Date: 9/20/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 10/4/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 11-09-20 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3049	Rev A1								
100		0.00							
	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy bluefile and create labels per PPP D135-692-011	CHG002							
150	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
160	QC4- 100% Inspect kits for completeness	0.00							
QC	Memo	0.00							
Quality Control									

11-12-12 (2)

MLI 11-12-12 (2)

11-12-12 (2)

11-12-12 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 Packaging	Packaging	0.00							
Packaging	Memo Identify and pack for shipping as per PPP D135-692-011 Location: <u>E6011</u> PPP Rev: _____	0.00							
180 QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.00							 11-12-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 73966

Parent Item: D135-692-011

Parent Item Name: Bearpaw



Start Date: 9/20/2011

Required Date: 10/4/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:C04.02.17 Blank size changed, Tolerance added Step 3 KJ/JLM
IPP Rev:D 08-04-16 Added Step 2 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-15A

Purchased

No

160

Each

471.0000

8

16



Bolt

Location

Loc Qty

Loc Code

ST358

471

118112

4

118648

267

118706

200

AN960JD416

NAS1149D0463J

Purchased

No

160

Each

0.0000

8

16



Washer

D2182B

Manufactured

No

160

f

73.5212

2

4



Rubber Cushion

Location

Loc Qty

Loc Code

ST410

73.52117

66063

73.52117

(D2182B060) Cut 4 at 6.00"

D2274

Manufactured

No

160

Each

644.0000

8

16



Radius Block

Location

Loc Qty

Loc Code

ST010

243

69736

9

73389

234

ST011

401

72121

401

119749

119078

73932

74438

[Handwritten signature]

[Handwritten signature]

[Handwritten signature]

[Handwritten signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Tuesday, September 20, 2011 10:19:56 AM

Page 2

Work Order ID: 73966

Parent Item: D135-692-011

Parent Item Name: Bearpaw

Start Date: 9/20/2011

Required Date: 10/4/2011

Start Qty: 2.00

Required Qty: 2.00

D2519

Manufactured No

160

Each

25.0000

4

8

Clamp

Location

Loc Qty

Loc Code

ST462

25

65118

25

Manufactured No

160

Each

647.0000

8

16

D2529

Washer

Location

Loc Qty

Loc Code

ST016

647

71161

250

73486

397

Manufactured No

160

Each

0.0000

2

4

D3049-1

Bearpaw

MS21042L4

Nut

Purchased No

160

Each

4,309.000

8

16

Location

Loc Qty

Loc Code

ST300

4309

117441

51

117601

637

117885

621

118451

2000

118927

1000

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 73966

Parent Item: D135-692-011

Parent Item Name: Bearpaw



Start Date: 9/20/2011

Required Date: 10/4/2011

Start Qty: 2.00

Required Qty: 2.00

QS100-M24S

Purchased

No

160

Each

29.0000

4

8



Clamp



[Signature] 9/12/11 (2)

Location

Loc Qty

Loc Code

ST449

29

117291

19

118090

10

117291

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

32.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D135-692-011 Bearpaw Installation on model EC135 aircraft	11.8 lb 5.36 kg	0.0 in 0.0 m	0.0 lb-kg 0.0 m-kg	199.7 in 5.07 m	2356 in-lb 27.2 m-kg

32.4 PARTS LIST

Qty	Part Number	Description
X	D135-692-011	BEARPAW INSTALLATION
4	D2182B060	RUBBER CUSHION
8	D2274	RADIUS BLOCK
2	D3049-1	BEARPAW
8	D2529	WASHER
8	D2519	CLAMP
8	AN4-15A	BOLT
8	AN960JD416	WASHERS
8	MS21042L4	NUT (OR MS21042-4)
4	QS100M24S	CLAMP

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